

# Work Order ID 73947

Tuesday, September 20, 2011 10:15:25 AM



Page 1

Item ID: D412-698-043

Accept



Setup Start



Revision ID:

Item Name: Hinge Panel Automatic Door Opener, LH (Spacedoor)

Stop



Start Date: 9/20/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 10/4/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: MF

Date: 11-09-20 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
DSI 9548	A

100



DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile & type labels per PPD412-698-043 CHG001

8/20/13

110



Packaging

Packaging

Pick Kit

Memo

11/9/2011

120



QC

Quality Control

QC4- 100% Inspect kits for completeness

Memo

8/20/13

ⓧ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 73947

Tuesday, September 20, 2011 10:15:25 AM



Item ID:	D412-698-043	Accept		Setup	Start	
Revision ID:						
Item Name:	Hinge Panel Automatic Door Opener, LH (Spacedoor)			Stop		
Start Date:	9/20/2011	Start Qty:	1.00			
Required Date:	10/4/2011	Req'd Qty:	1.00			
Reference:						
				Cust Item ID:		
				Customer:		

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Pick Kit	0.00							
Packaging	<b>Memo</b>	0.00							
Packaging	Identify and pack for shipping as per PPP D412-698-043 Location: _____ PPP rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
QC	<b>Memo</b>	0.00							
Quality Control									

*closed at 4*

*used for testing*

*remaining stock pulled on 0700 rev*

*see Russ*

*MF 11-10-24*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, September 20, 2011 10:15:20 AM

Page 1

Work Order ID: 73947

Parent Item: D412-698-043

Parent Item Name: Hinge Panel Automatic Door Opener, LH (Spacedoor)

Start Date: 9/20/2011

Required Date: 10/4/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 11.08.18 new issue DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3552-21



Door Prop

Manufactured

No

110

Each

1.0000

1

1



B73948

Location

Loc Qty

Loc Code

ST

1

68168

1

D3622-1



Ball Stud

Manufactured

No

110

Each

29.0000

1

1



5

Location

Loc Qty

Loc Code

ST070

29

72102

29

D4330-041



Airframe Bracket Assembly, LH

Manufactured

No

110

Each

0.0000

1

1



73949

D4330-3



Door Bracket

Manufactured

No

110

Each

1.0000

1

1



B73951 11/9/2011

Location

Loc Qty

Loc Code

Eagle

1

67384

1

# Picklist Print

Tuesday, September 20, 2011 10:15:21 AM

Page 2

Work Order ID: 73947

Parent Item: D412-698-043

Parent Item Name: Hinge Panel Automatic Door Opener, LH (Spacedoor)

Start Date: 9/20/2011

Required Date: 10/4/2011

Start Qty: 1.00

Required Qty: 1.00

MS21042L5

Purchased

No

110

Each

1,287.000

1

1



Nut

Location

Loc Qty

Loc Code

ST300

1287

116105

5

116548

53

117441

343

117611

90

118179

496

118910

300

NAS1149D0563J

Purchased

No

110

Each

4,777.000

1



Washer

Location

Loc Qty

Loc Code

ST298

4777

118206

3777

118614

1000

80-005-2-8

Purchased

No

110

Each

121.0000

3

3



Insert

Location

Loc Qty

Loc Code

ST379

121

113109

121

110

Each

122.0000

3

3

MS27039-1-05

Purchased

No



Screw

Location

Loc Qty

Loc Code

ST291

122

3501

122

Tuesday, September 20, 2011 10:15:21 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, September 20, 2011 10:15:21 AM

Work Order ID: 73947



Parent Item: D412-698-043



Parent Item Name: Hinge Panel Automatic Door Opener, LH (Spacedoor)

Start Date: 9/20/2011

Required Date: 10/4/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0332J

Purchased

No

110

Each

2,046.000

3

3



Washer



1191268f

Location

Loc Qty

Loc Code

ST297

988

117087

988

ST298

1058

105793

12

118078

46

118384

1000

3



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

REFERENCE ONLY

5.0 WEIGHT & BALANCE:

INSTALLATION	WEIGHT	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D412-698-041 LH (Standard)	0.23 lb 0.10 kg	-43.63 in -1.11 m	-10.03 in-lb -0.11 m-kg	86.27 in 2.19 m	19.84 in-lb 0.22 m-kg
D412-698-042 RH (Standard)	0.23 lb 0.10 kg	43.63 in 1.11 m	10.03 in-lb 0.11 m-kg	86.27 in 2.19 m	19.84 in-lb 0.22 m-kg
D412-698-043 LH (Spacedoor™)	0.23 lb 0.10 kg	-43.63 in -1.11 m	-10.03 in-lb -0.11 m-kg	86.27 in 2.19 m	19.84 in-lb 0.22 m-kg
D412-698-044 RH (Spacedoor™)	0.23 lb 0.10 kg	43.63 in 1.11 m	10.03 in-lb 0.11 m-kg	86.27 in 2.19 m	19.84 in-lb 0.22 m-kg

6.0 PARTS LIST:

Qty -041	Qty -042	Qty -043	Qty -044	Part Number	Description
X				D412-698-041	HINGE PANEL AUTOMATIC DOOR OPENER KIT, LH (STANDARD)
	X			D412-698-042	HINGE PANEL AUTOMATIC DOOR OPENER KIT, RH (STANDARD)
		X		D412-698-043	HINGE PANEL AUTOMATIC DOOR OPENER KIT, LH (SPACEDOOR™)
			X	D412-698-044	HINGE PANEL AUTOMATIC DOOR OPENER KIT, RH (SPACEDOOR™)
1	1	1	1	D3552-21	GAS SPRING
1	1	1	1	D3622-1	BALL STUD
1		1		D4330-041	AIRFRAME BRACKET ASSEMBLY, LH
	1		1	D4330-042	AIRFRAME BRACKET ASSEMBLY, RH
1	1	1	1	D4330-3	DOOR BRACKET
		3	3	80-005-2-8	INSERT
1	1	1	1	MS21042L5	NUT
		3	3	MS27039-1-05	SCREW
		3	3	NAS1149D0332J	WASHER
1	1	1	1	NAS1149D0563J	WASHER

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED

BY:

D. SHEPHERD (DE # 02)

DATE: 11.04.26  
CERT. NO.: SH92-43  
ISSUE NO.: 5

DESIGN	DC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DC		
CHECKED	DE	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9548	SHEET 8 OF 8
APPROVED	TH	TITLE	SCALE
DE APPR.	TH	HINGE DOOR OPENER KIT	NTS
DATE	11.04.26	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	